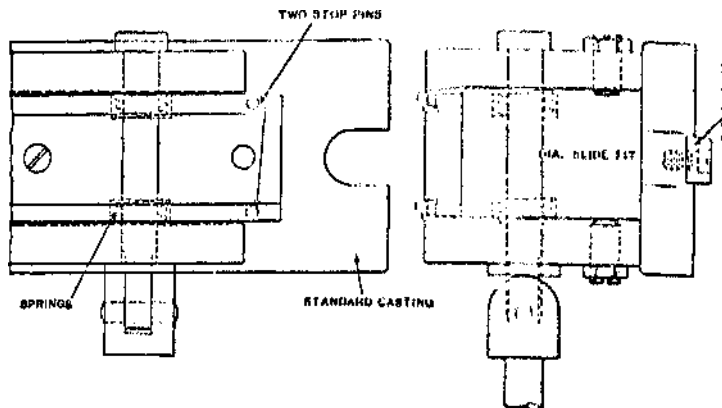


Adjustable Fixture for Angular Work. — Occasionally in every line of manufacture there are parts which are simple in appearance, but difficult to machine. Fig. 5 shows a part of a belt shifter used on an automatic machine, the makers of which use eight different shaped pieces of this kind. The stock is flat and one-half inch thick. If the sides of the slots were perpendicular, the manufacture of these pieces would be very simple, but the sides are not perpendicular, and the angles they form with the bottom differ with each different shaped piece. As a result, these pieces are difficult to manufacture without the proper form of fixture.



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Margin try

Fig. 4. Fixture for
Machining Two Flutes in
One Operation

The fixture shown in Figs. 6 to K consists of two parts A and B, which are clamped together, when in the proper position, by bolts

passing through holes in the* lower casting *A* and slots in the upper casting *K*. A tongue planed in flu* bottom of the base *A* fits a slot in the* milling machine* table, to which the base is bolted. The upper part *II* is turtu't! to lit the* lower part so that no gib is required. The parts to be milled are held in place by a set-screw,, which is not shown. Kadi shape has its own number, and these* numbers an* stamped upon the top surface of the base *A*. The upper part of the fixture can move in either direction from I lit* renter, so thai by placing